

Date: Monday, 04/02/2008 3:08:27 PM
 User: Dominique Dube

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 407 STEP ASSEMBLY (1)
 Job Number : 37017
 Estimate Number : 11798
 P.O. Number :
 This Issue : 04/02/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D206628034
 First Issue : 25/01/2008 Type : LARGE FAB ASSY Drawing Number : N/A
 Previous Run : 33924 Drawing Revision :
 Material :
 Written By : Due Date : 10/03/2008 Qty: 4 Um: Each
 Checked & Approved By :
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-034 CHG-002 003

08.02.27

2.0 37017A FLOAT STEP ASSEMBLY RH (206/407)



Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2842-042 B 37017A SQ

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

UPDATED AS PER ECN 1118, D206-268-034 CHG NUM. 003

4.0 D27313 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-3 Mounting Lug 33995

5.0 D28441 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1 Arm 37243

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Job Number: 37017

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2844-3 Arm 34876

7.0

D2732030

Rubber Cushion



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part # Description Batch

8 D2732-030 RUBBER CUSHION 34717

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-041 LUG ASS'Y 30997

9.0

AN4C14A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN4C14A Bolt M102087

10.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3C4A Bolt M105559

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4C15A Bolt M103910

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37017

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 12.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10 WASHER

M106302

13.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L Washer

M106785

14.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L Washer

M105792 M105408

15.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4 Nut (or MS21042-4)

M106763100

M10710120

16.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3 Washer

M106431

8/2/27 (1)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

000270

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37017

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-034

Location:

PPP Rev:

D 8/2/27 SQ (1)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/02/27 (1)

Job Completion



2008/2/27 (1)

split

628-034

Dart Aerospace Ltd.

11

Date: Friday, 1/25/2008 11:28:44 AM
User: Kim Johnston



Process Sheet

shp 27/03

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP ASSEMBLY RH (206/407)
Job Number	: 37017A		
Estimate Number	: 11775		
P.O. Number	:	Part Number	: D2842042
This Issue	: 1/25/2008 S.O. No. :	Drawing Number	: D2842 REV B
Prsht Rev.	: NC	Project Number	:
First Issue	: 1/1 Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 33922A	Material	:
Written By	:	Due Date	: 3/10/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>08 01 25</u>		
Comment	: Est Rev'd As Per Ecn 766 06-01-06 JLM		

Additional Product



Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
	Qty Part # Description Batch:	
	1 D2622-120C Extrusion	B35618
Check Material for any Dents or Defects		



SAW 08/02/25 (4)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut D2842-1 using D2622 extrusion as per Dwg D2842		
2-Drill D2842-1 using Jig DT8272 as per Dwg D2842		
3-Deburr and bevel ends for welding		

SAW 08/02/25 (4)

3.0	D2734	206 Step Endplate
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
206 Step Endplate		
Pick:		
	Qty Part Number Description Batch	
	2 D2734 End Cap	B36520

08-02-26 4

4.0	D34591	plate
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
plate		
Batch: 34429		

08-02-26 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 11:28:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 37017A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

plate

Batch: 34430

SE 08.02.26 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg D2842

A/R AL Rod Batch: M105058
M106762

2-Grind end cap weld flush

SE 08.02.26 4

SAD 08.02.26 ①

7.0

DO NOT USE

WELD INSPECTION



Comment: WELD INSPECTION

PD 08.02.26 ①

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08.02.26 1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE 08.02.26 1

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M105058

2-Grind end cap weld flush.

SE 08.02.26 1

SAD 08.02.26 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 11:28:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 37017A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-02-26 ①

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-27 ①

13.0

POWDER COATING

POWDER COATING



M10700 S



①X

Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

m-l 08/02/27

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/02/27 ①

15.0

NAS1329C3KB130

insert



*

Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

M105385

m-l

16.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M106785

m-l

17.0

NAS1515H3L

WASHER



①X

Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

M106516

m-l 08/02/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 08/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 11:28:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 37017A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

M107008

M.L

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch:

M106894

M.L 08/02/27

(IX)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

James (V)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

AP 37017

8/2/27 SR

(IX)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AP 8/2/27

Job Completion



2008/2/27 (I)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

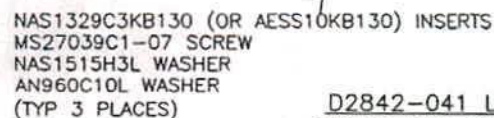
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. B
CHECKED 	APPROVED 	DRAWING NO. D2842	SHEET 1 OF 1	
DATE 05.09.23	TITLE 206L/407 FLOAT STEP ASSEMBLY		SCALE NTS	
A	98.10.13	NEW ISSUE		
B	05.09.23	RE-DESIGN, ADD D3459-1/-3		



NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AES510KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14

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